

Date: Thursday, 3/30/2006 10:06:13 AM
 User: Kim Johnston

Process Sheet

Split

SD
06/05/02

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26452A-1
 Estimate Number : 10375
 P.O. Number : N/A
 This Issue : 3/30/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : 26211A
 Drawing Name : STEP SPACER
 Part Number : D30651
 Drawing Number : D3065 REV. A2
 Project Number : N/A
 Drawing Revision : A2
 Material : N/A
 Due Date : 4/15/2006
 Qty: 60 Um: Each
 Written By : SEE IN COMMENT BELOW
 Checked & Approved By : 06.03.30
 Comment : Est:C 02/1.01 Incorporated D3066-1 IPP KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.1300 sf(s)/Unit Total: 7.7994 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: M9659

M9295

2.0 SHEAR



SHEAR



Comment: SHEAR

Cut blank: 3.600" x 4.500" Grain along 4.500"

06.05.02

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA182 and Dwg D3065

Stack of 15

Identify as D3065-1

Water jet

06.04.25 (60)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06.04.25 (60)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06.04.25 (60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Part Helicopters Services

Drawing Name: STEP SPACER

Job Number: 26452A

Part Number: D30651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

H.M 06-05-01

55

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 06/05/02

55

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-02 (55)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06-05-02

(55)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/05/02

(55)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/05/02

(55)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/04

(55)

Job Completion



U 0605-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

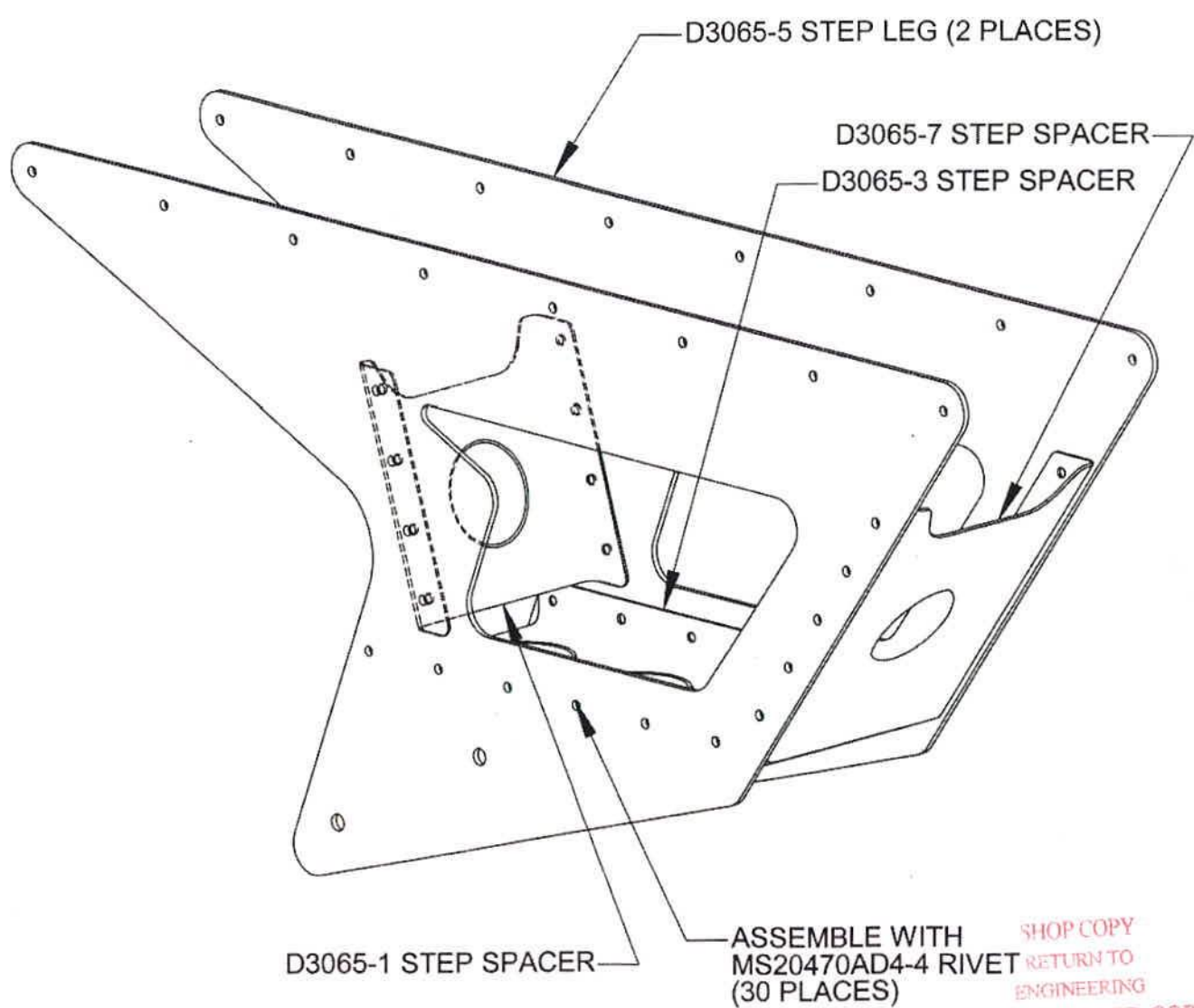
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	OP	DRAWN BY	OP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	OP	APPROVED	OP	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE	02.09.11			TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11			NEW ISSUE	
A1	03.02.13 OP			ADD SLOTS TO D3065-5	
A2	03.02.27 OP			0.551 WAS 0.410	

RELEASED
02.09.20



D3065-041 STEP LEG ASSEMBLY

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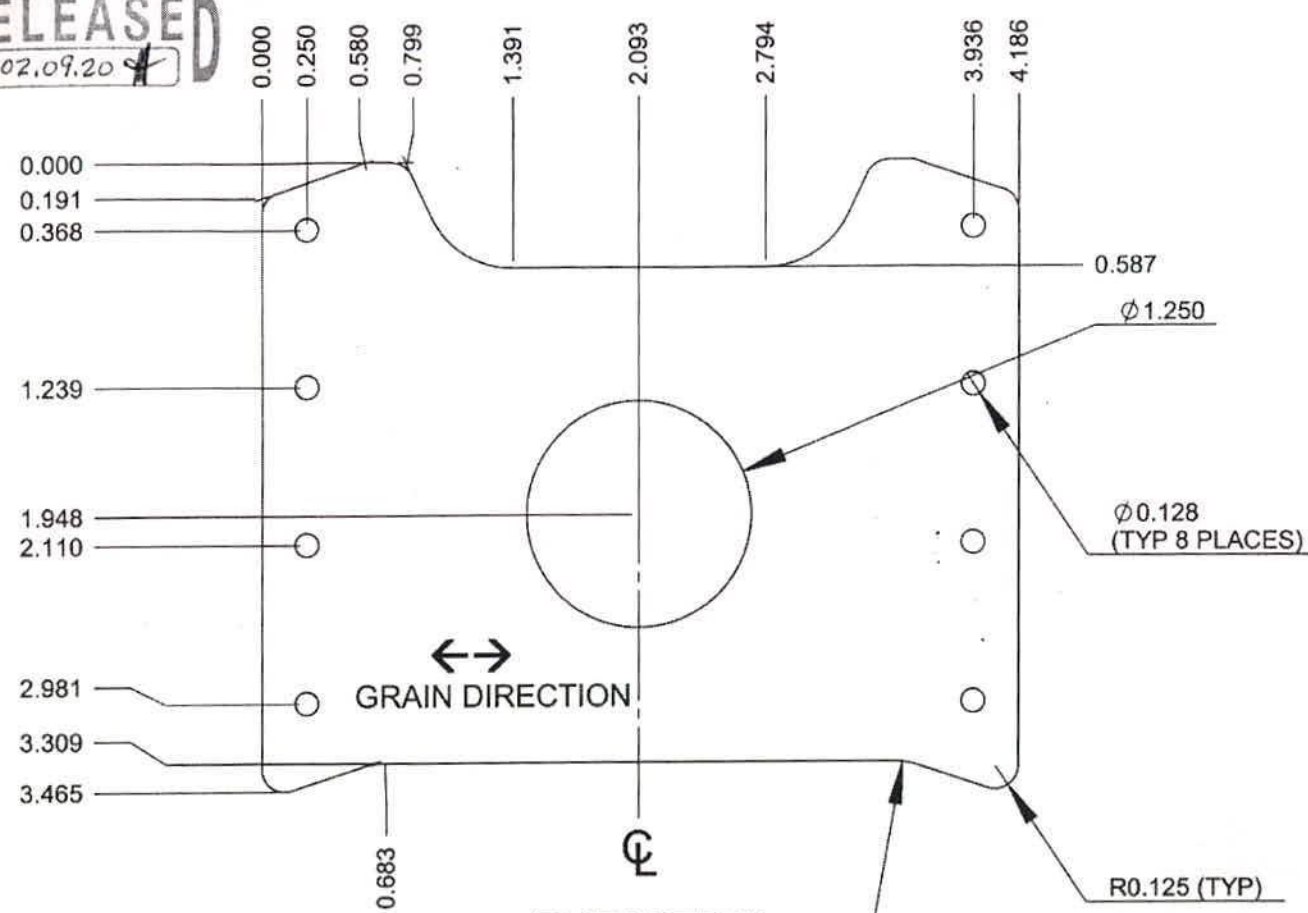
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 *[Signature]*



FLAT PATTERN

BEND DETAIL

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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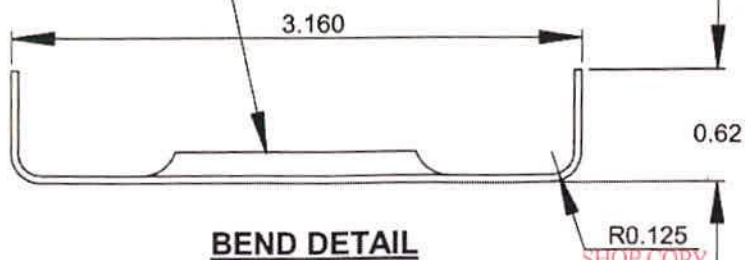
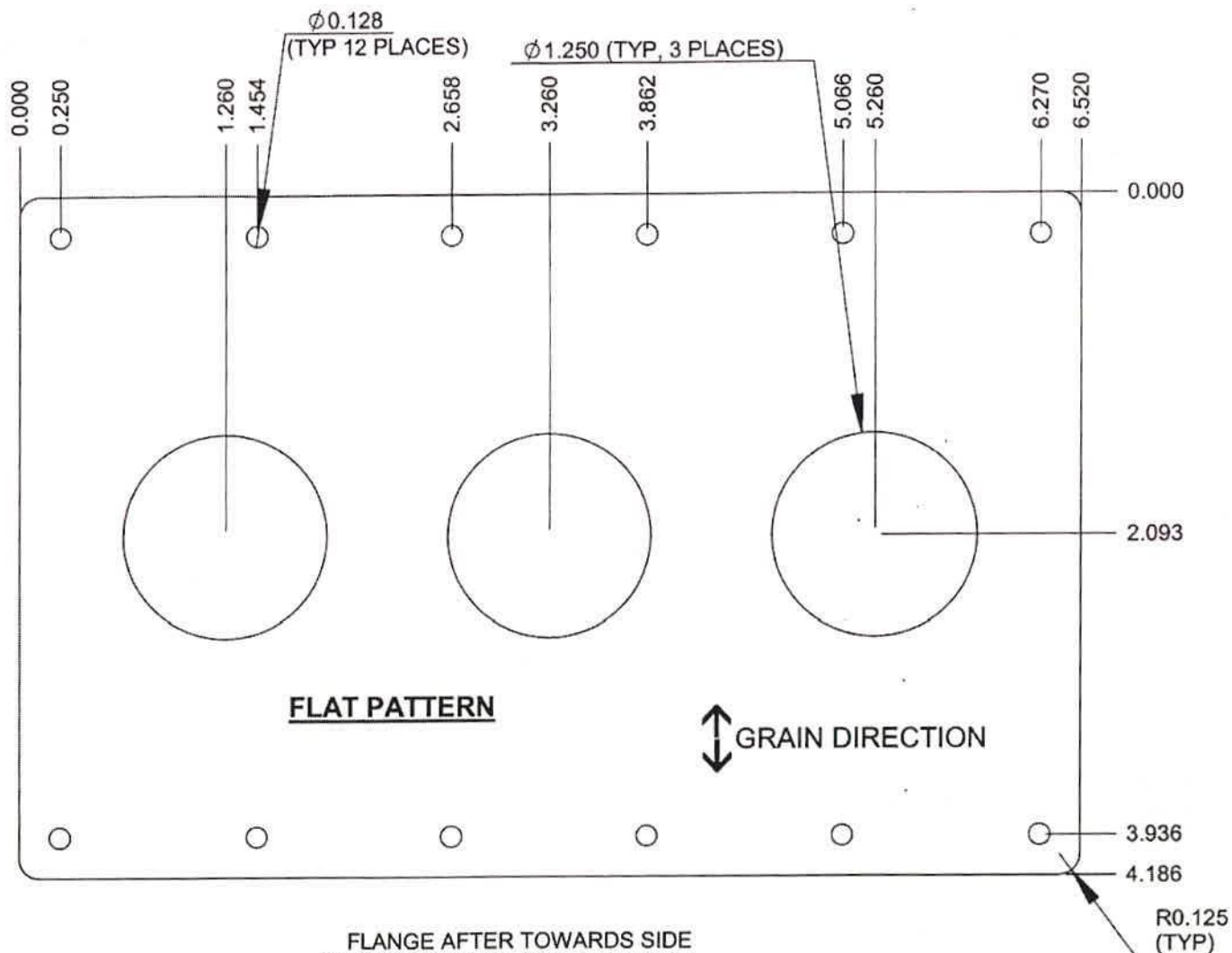
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DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:1



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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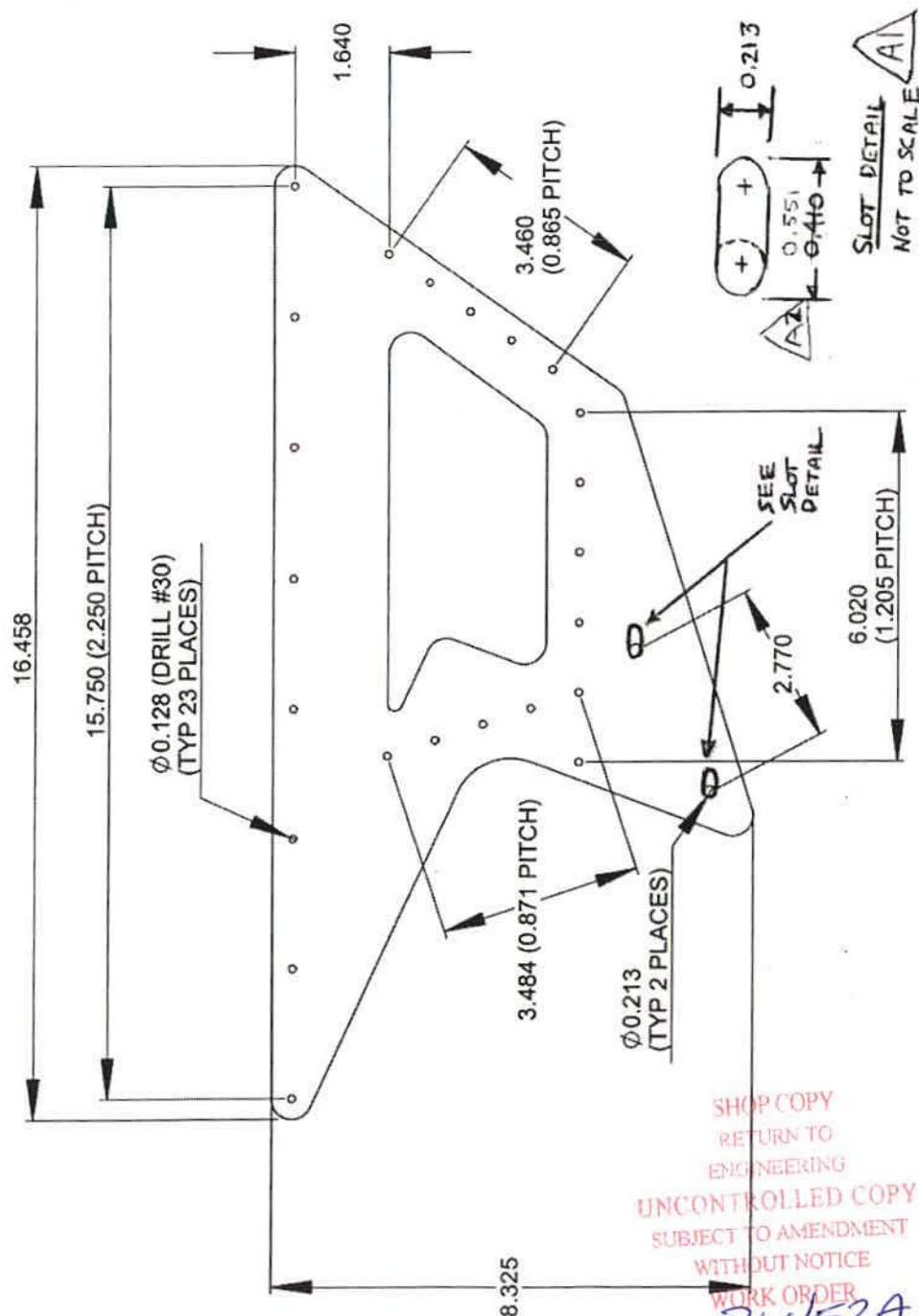
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WORK ORDER
26452A



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DATE 02.09.11		TITLE STEP LEG ASSEMBLY SCALE 1:3	

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02.09.20 #



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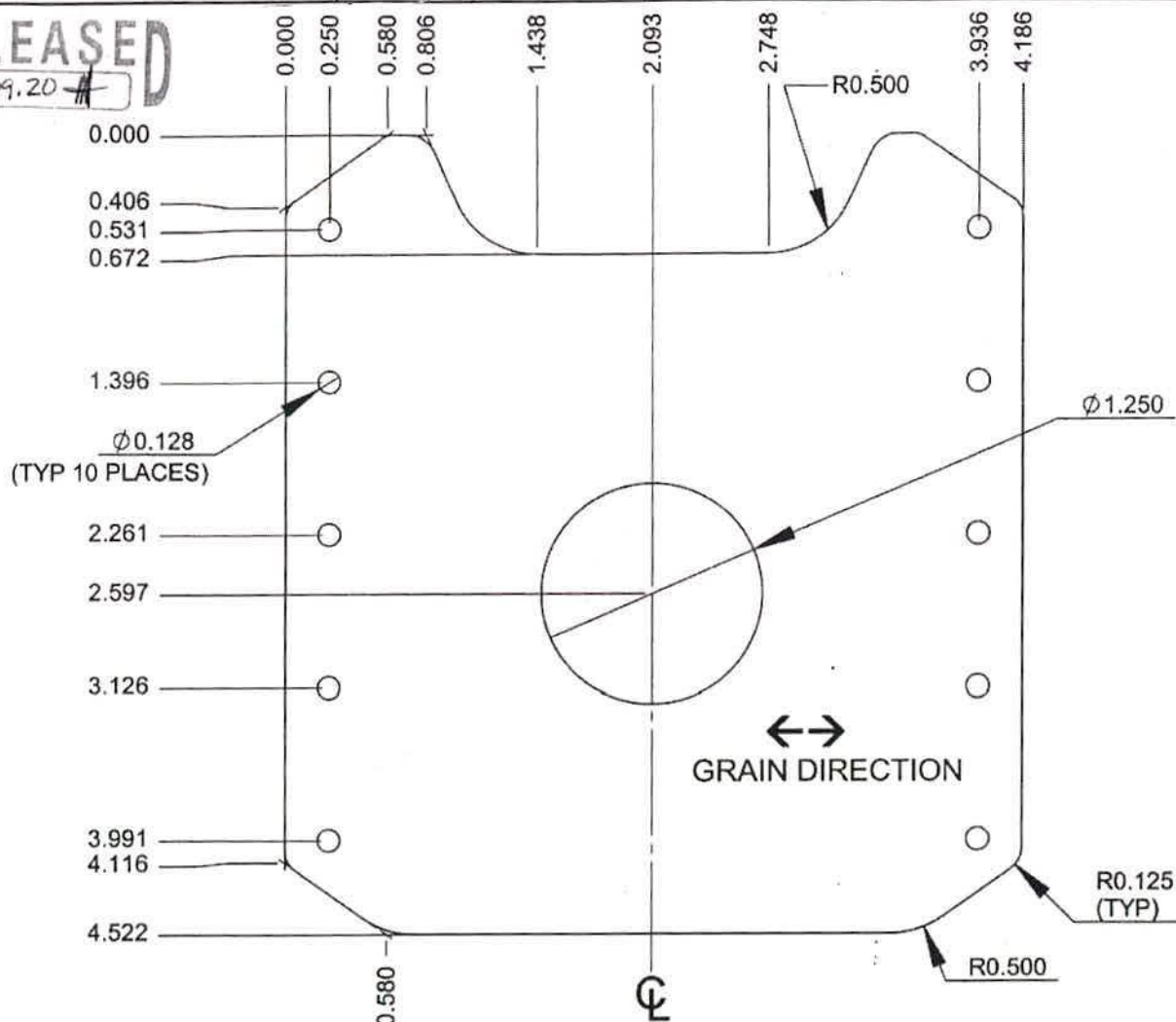
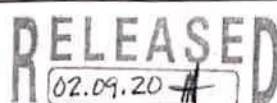
1) MACHINE PER DWG FILE "D3065.5 SI DPT"

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

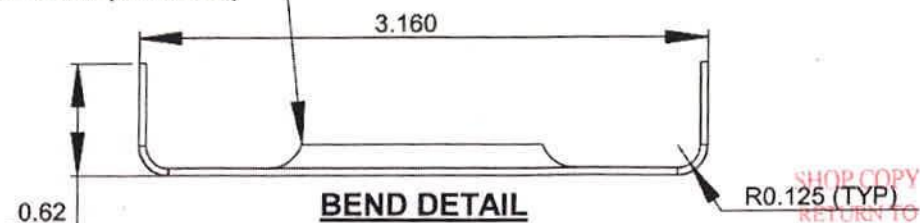
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY SCALE 1:1	



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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